

FIG. 1
(Prior Art)

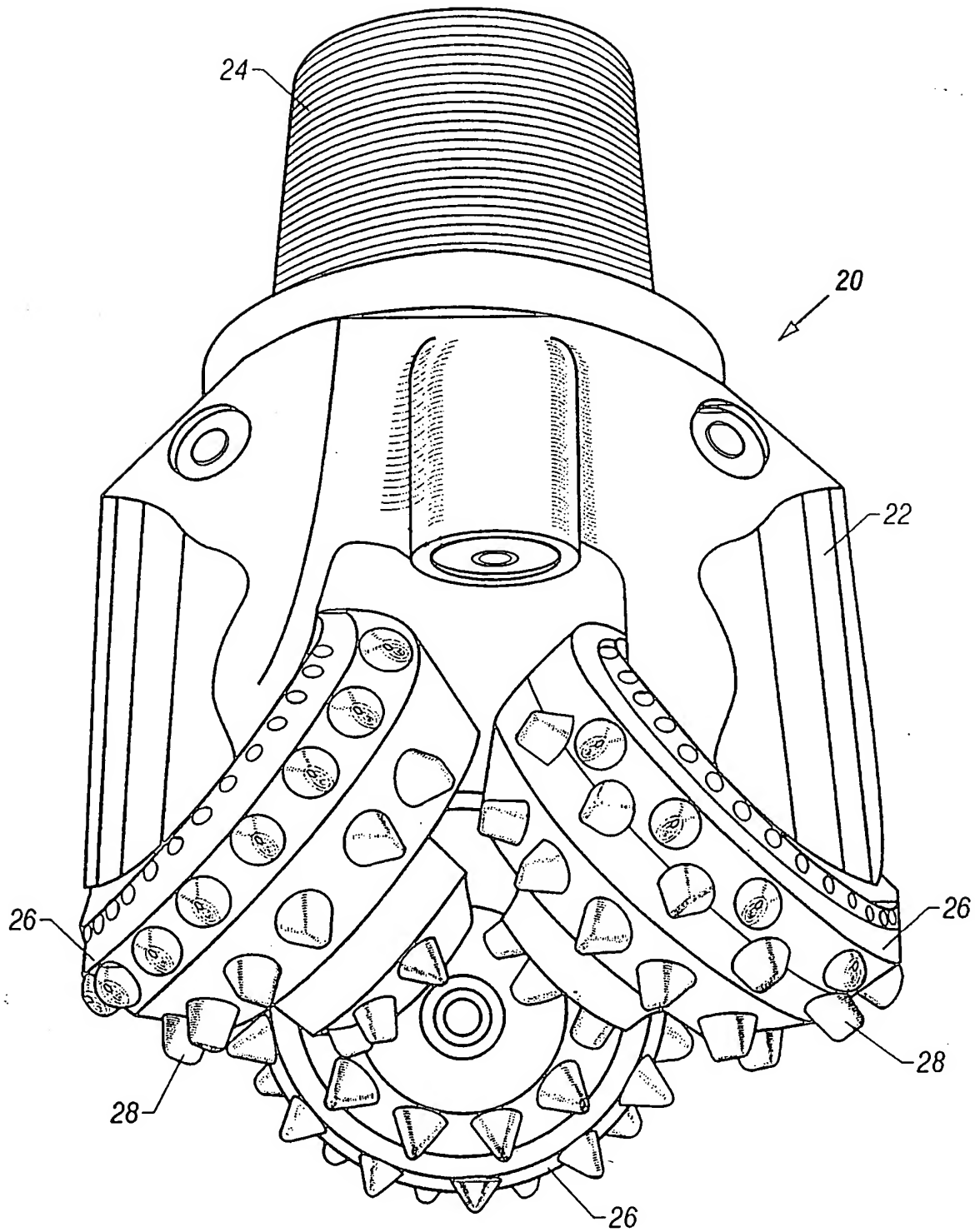
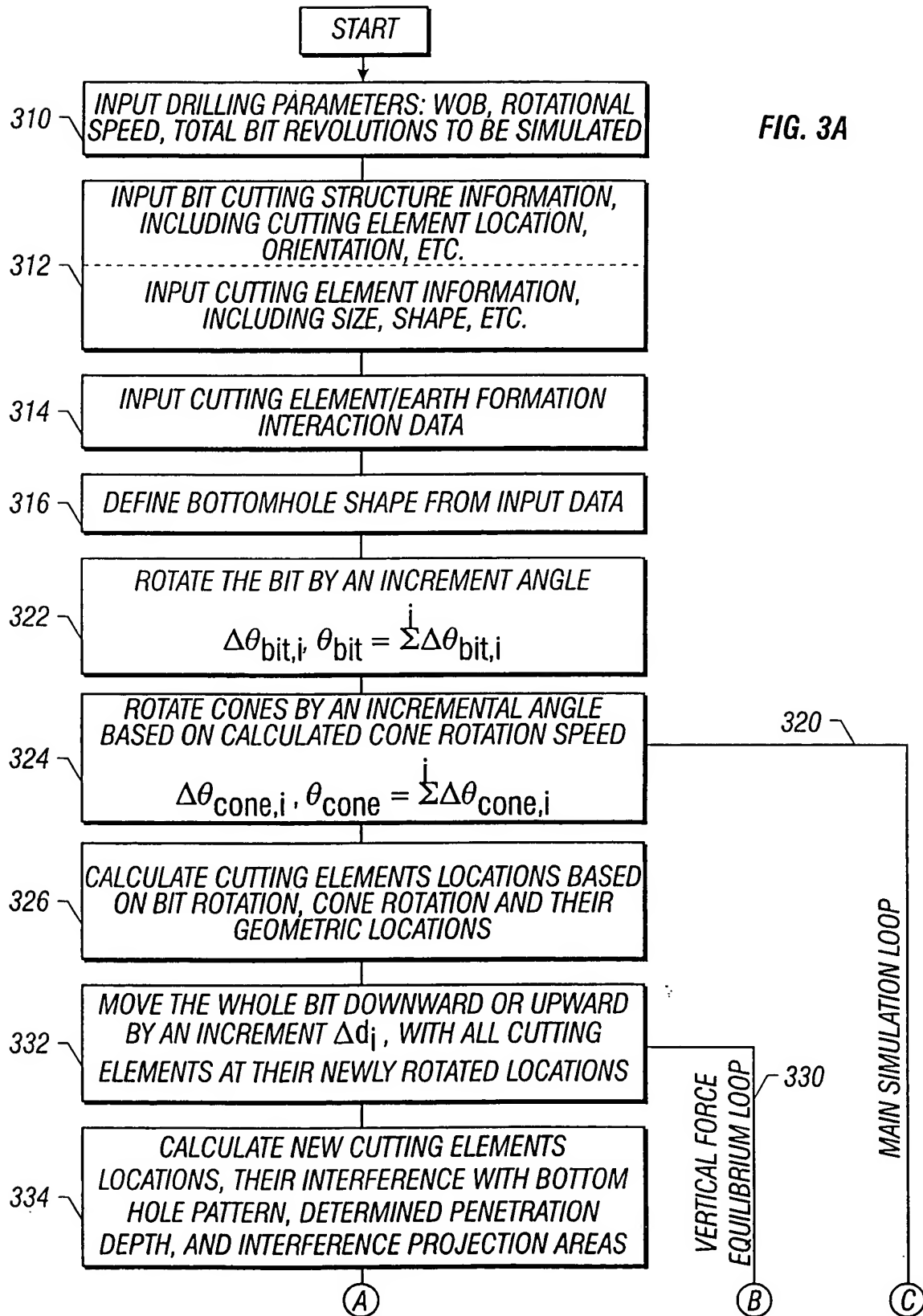


FIG.2
(Prior Art)



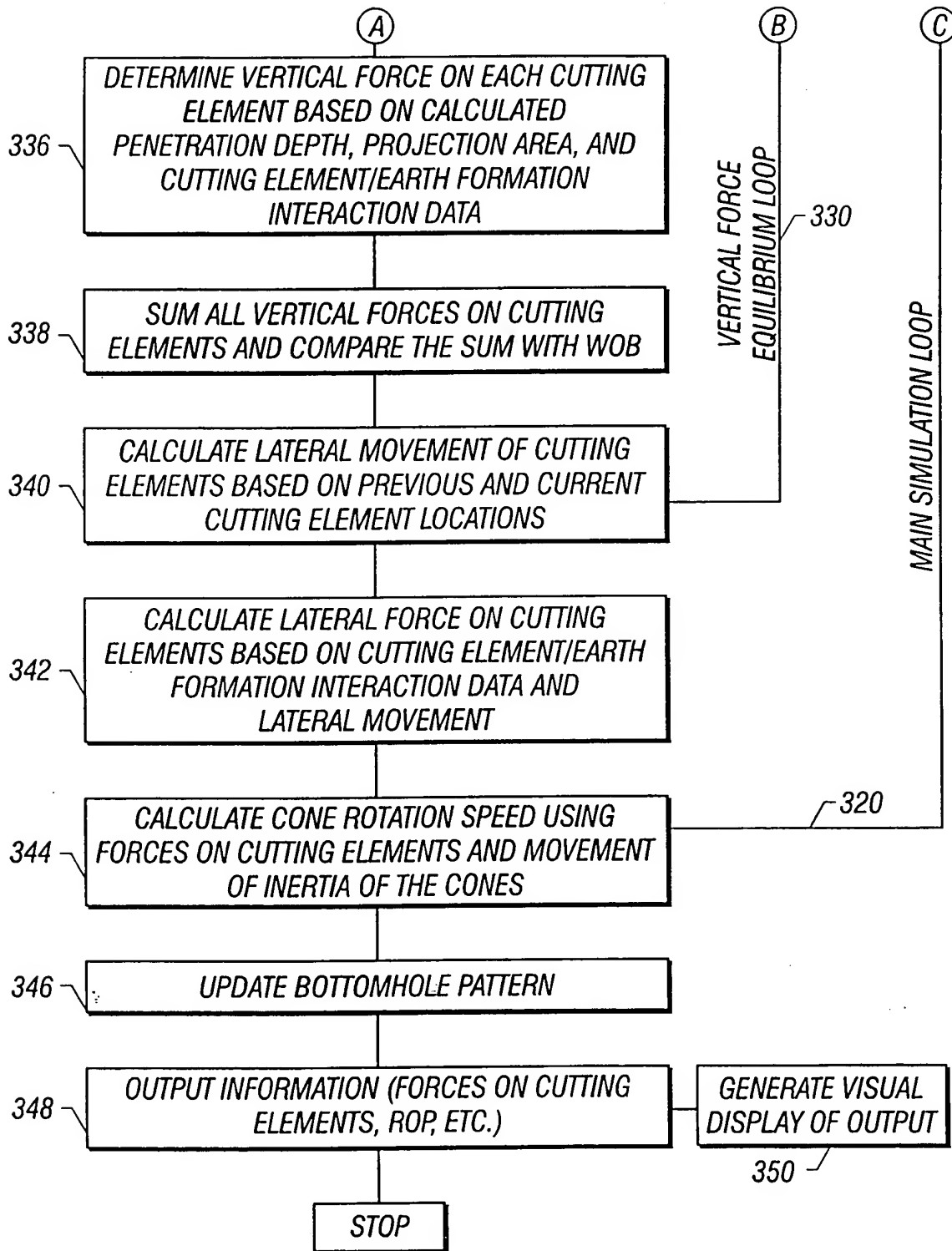


FIG. 3B

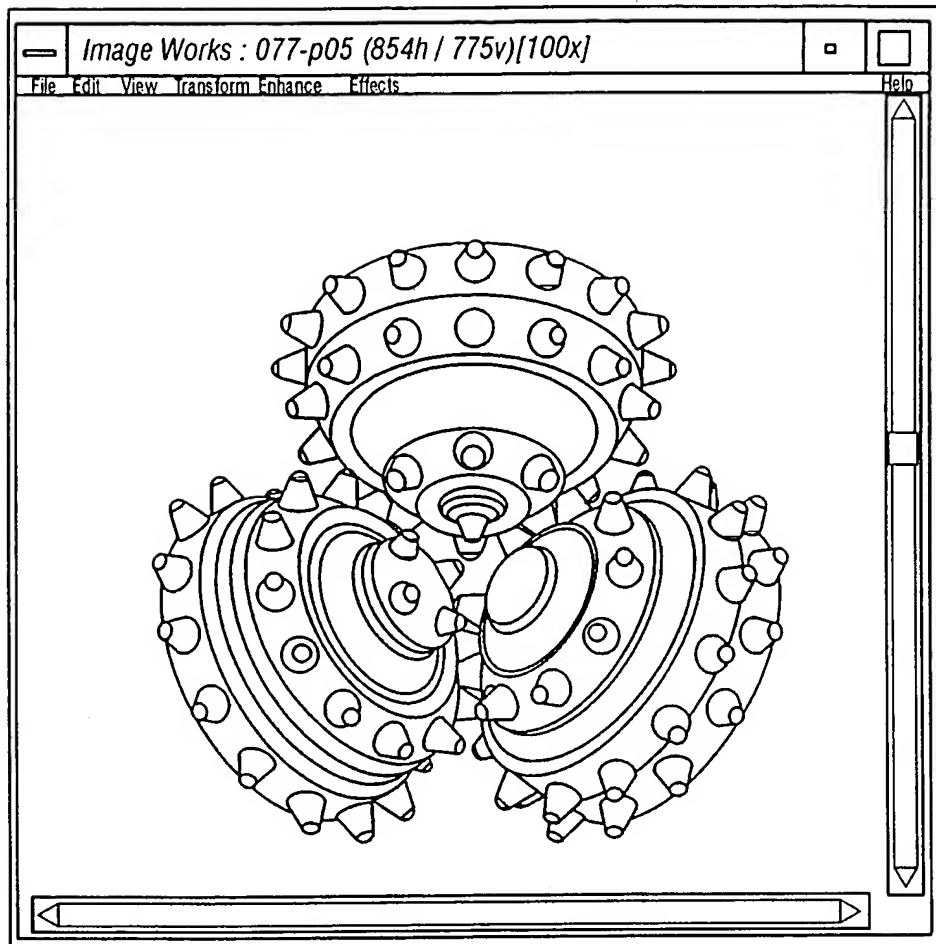


FIG. 4

6/17

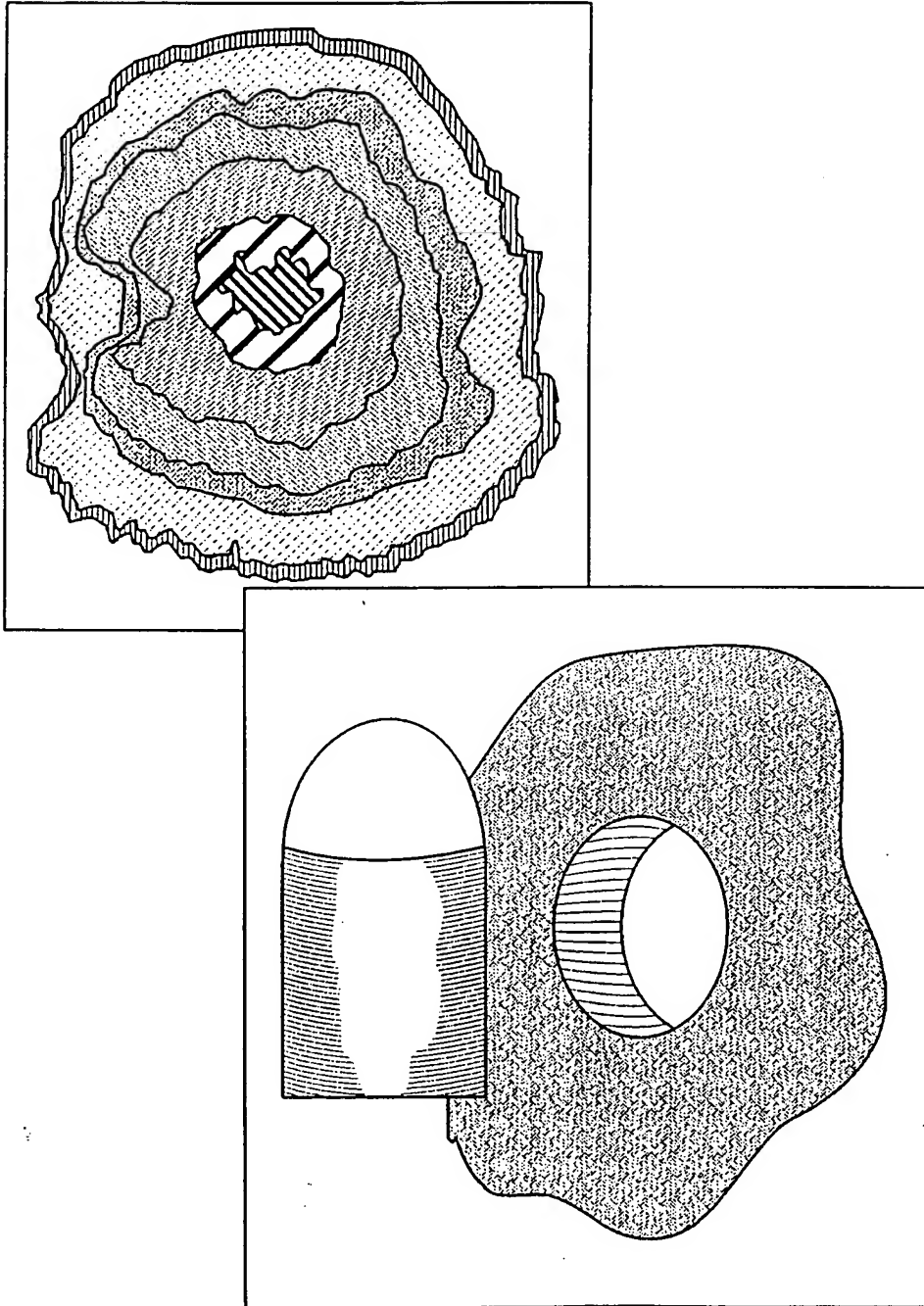


FIG. 5

7/17

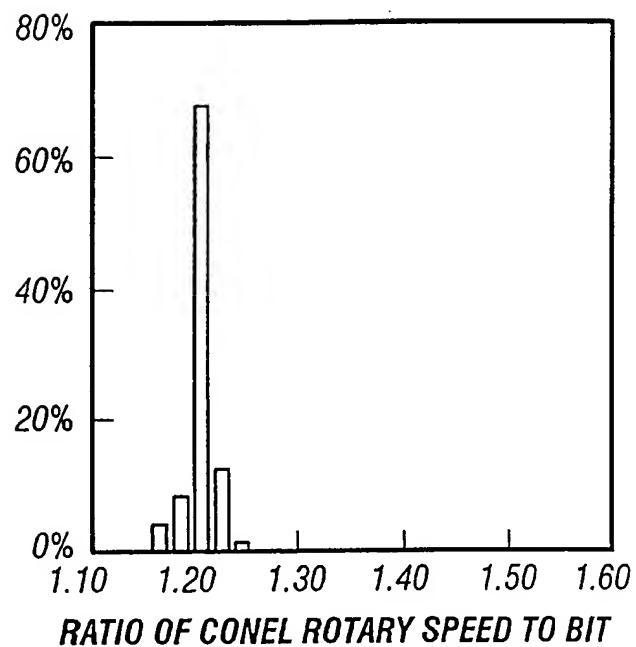


FIG. 6A

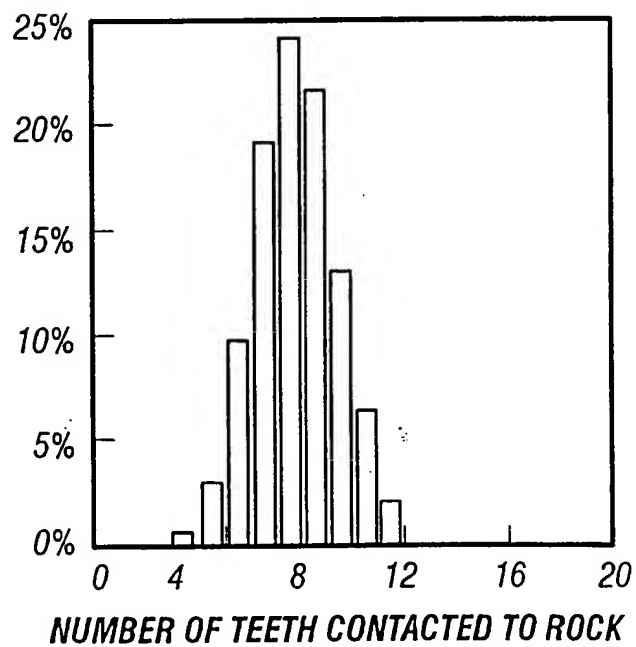


FIG. 6B

8/17

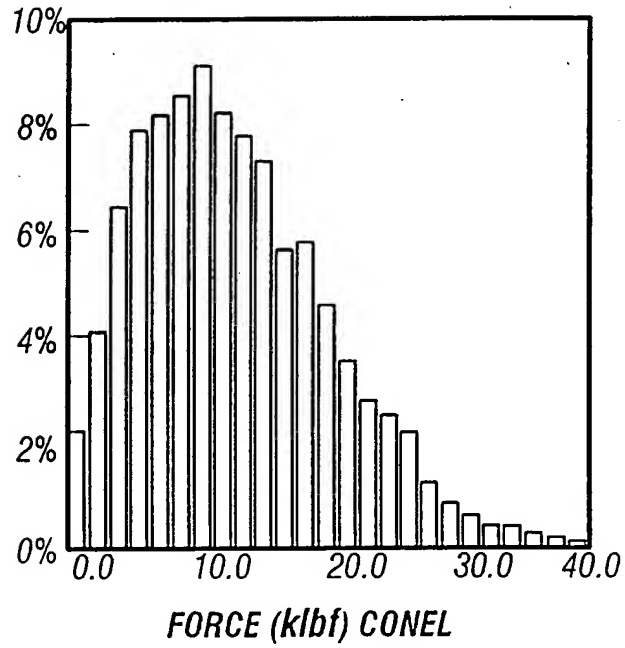
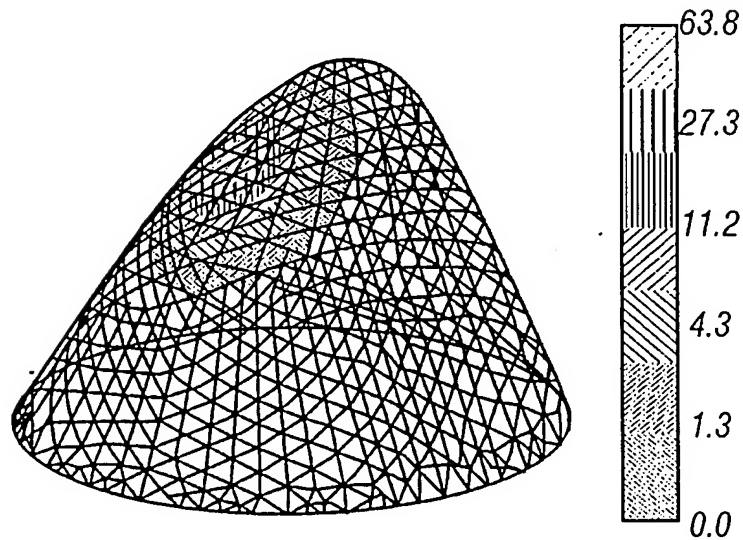


FIG. 6C



INSERT CUMULATIVE CUTTING

FIG. 6D

9/17

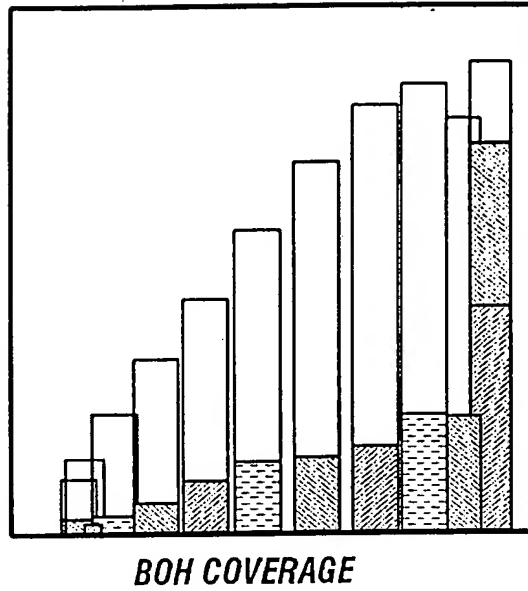


FIG. 6E

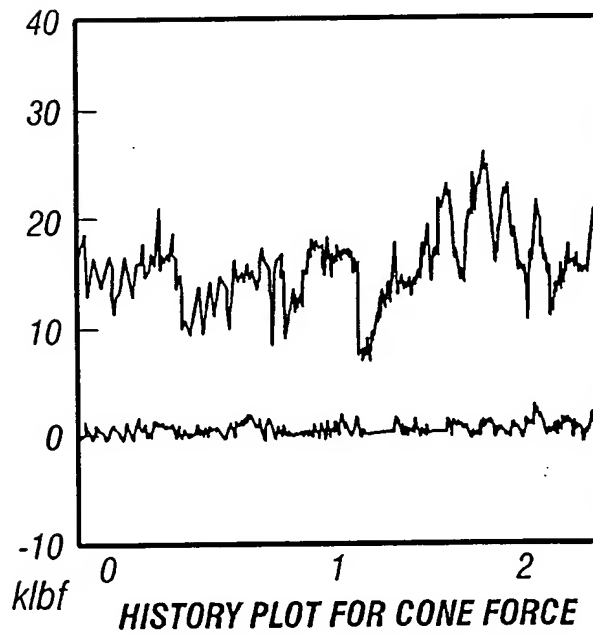


FIG. 6F

10/17

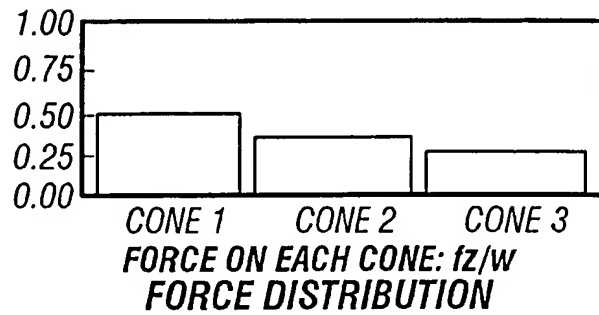
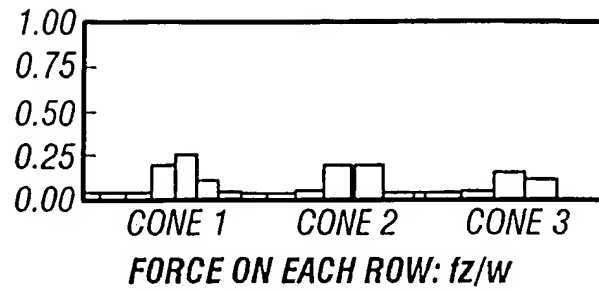
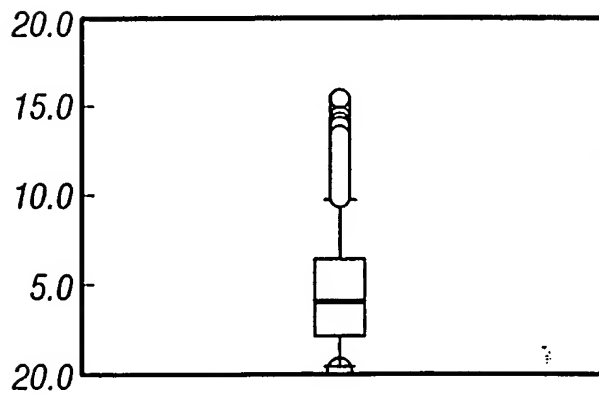


FIG. 6G



FORCE (klbf) 1C-3R
BOX & WISKERS PLOT FOR ROW FORCE

FIG. 6H

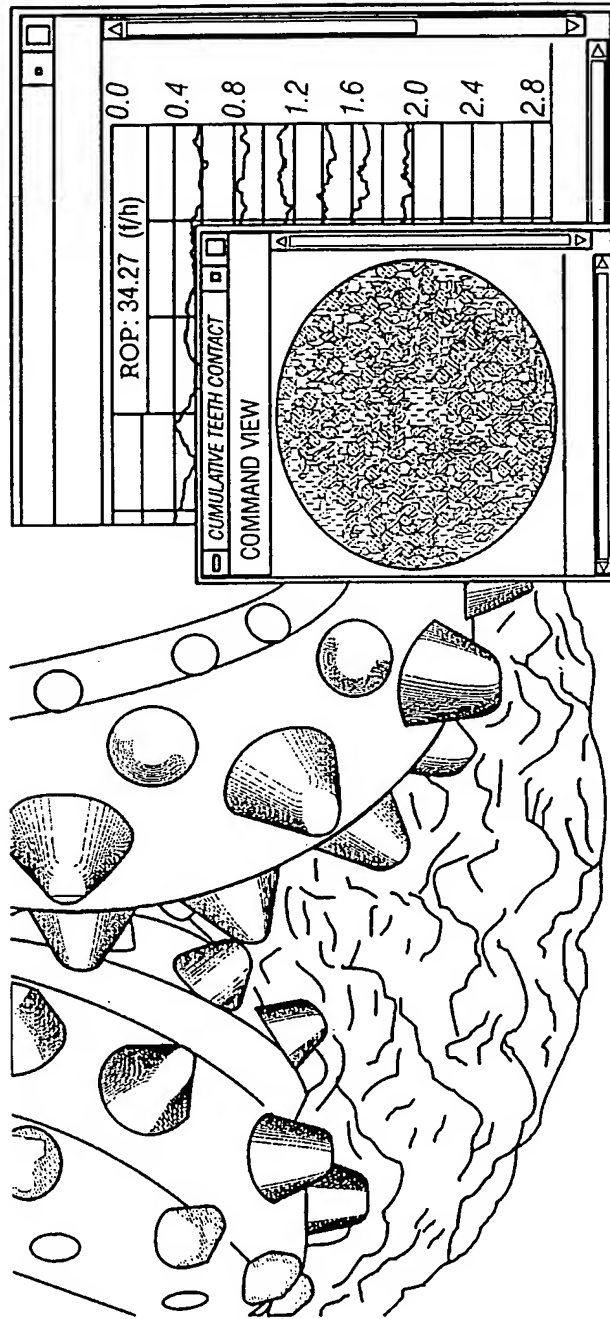


FIG. 7

12/17

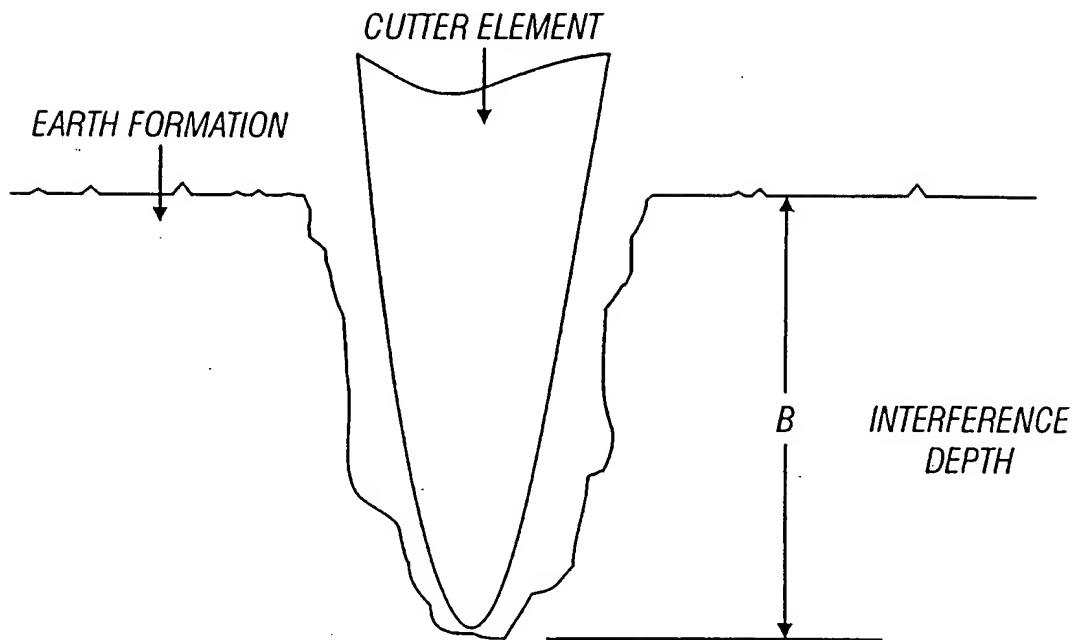


FIG. 8A

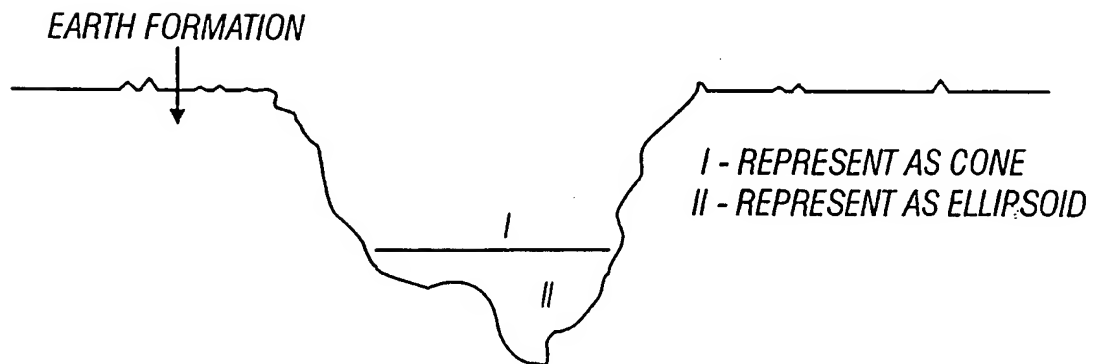


FIG. 8B

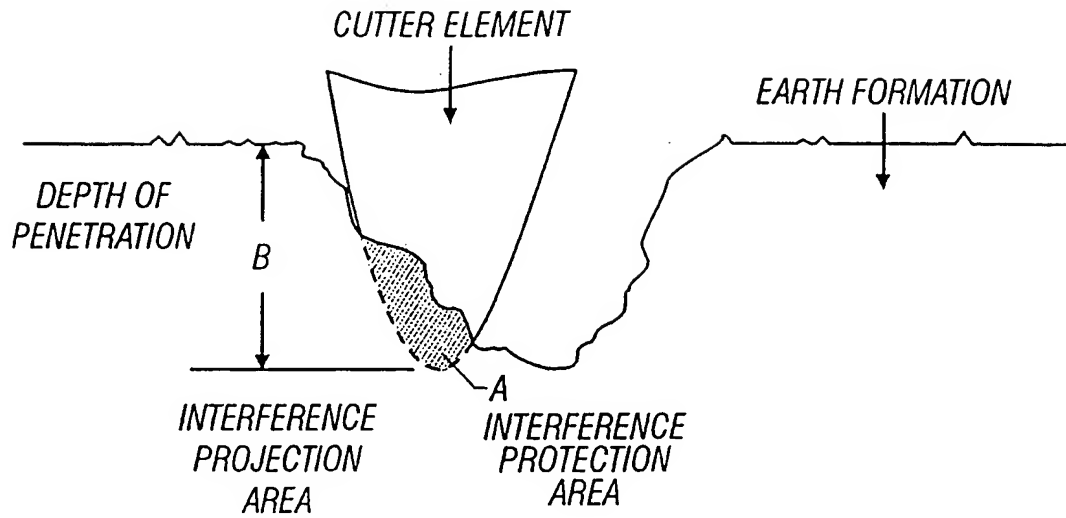


FIG. 8C

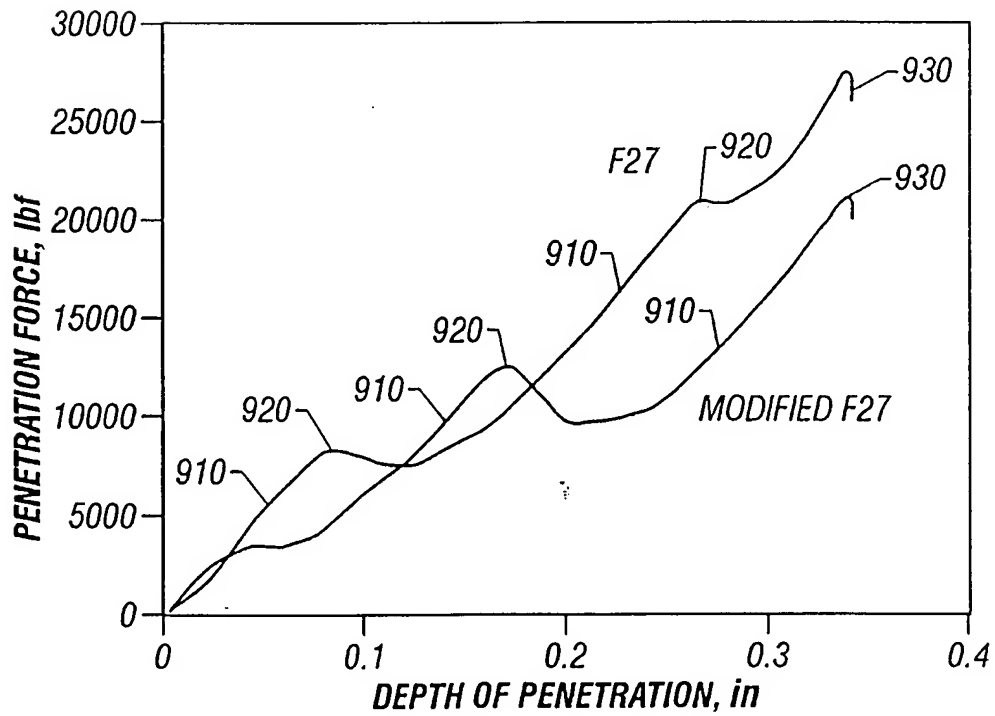
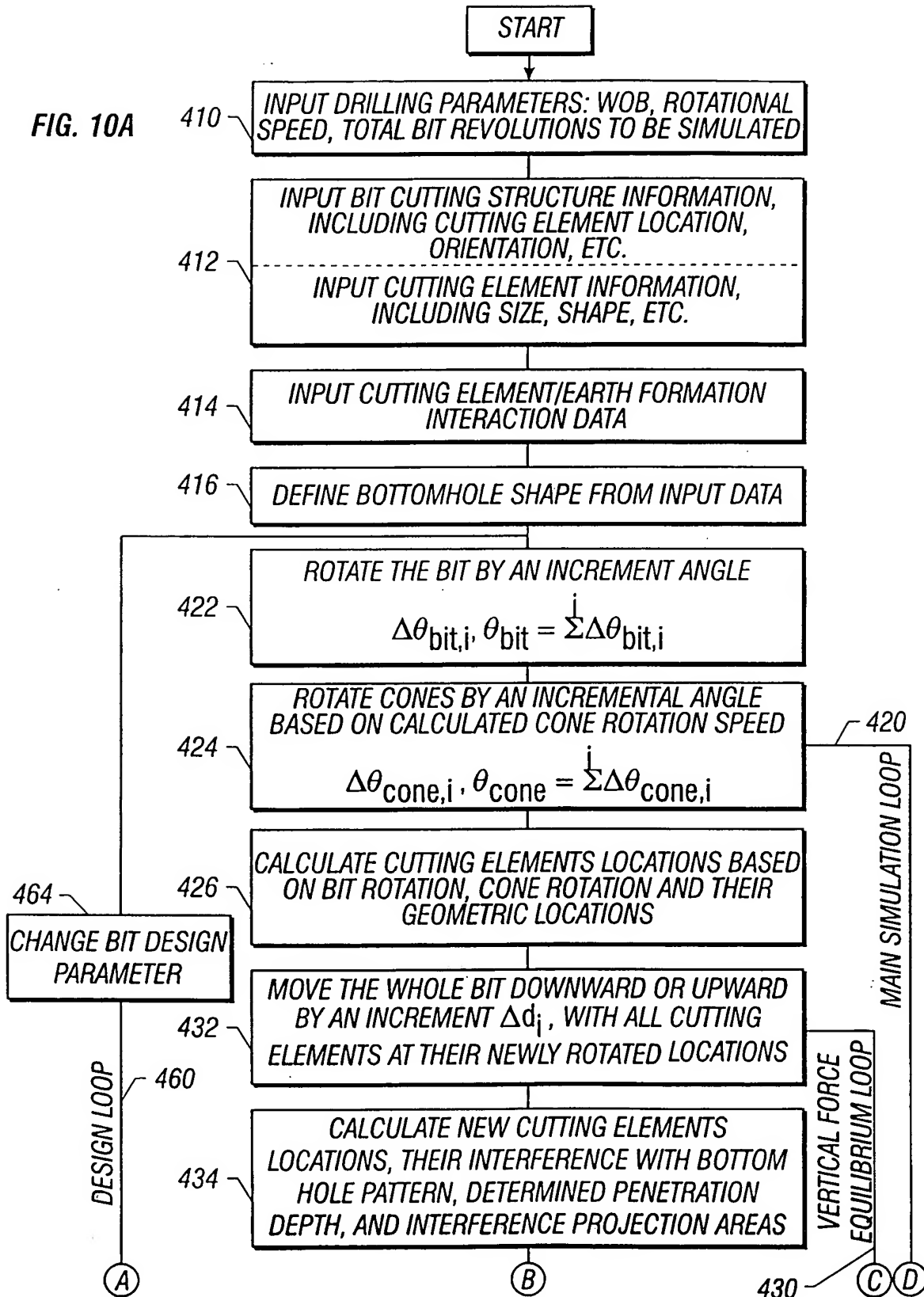


FIG. 9

FIG. 10A



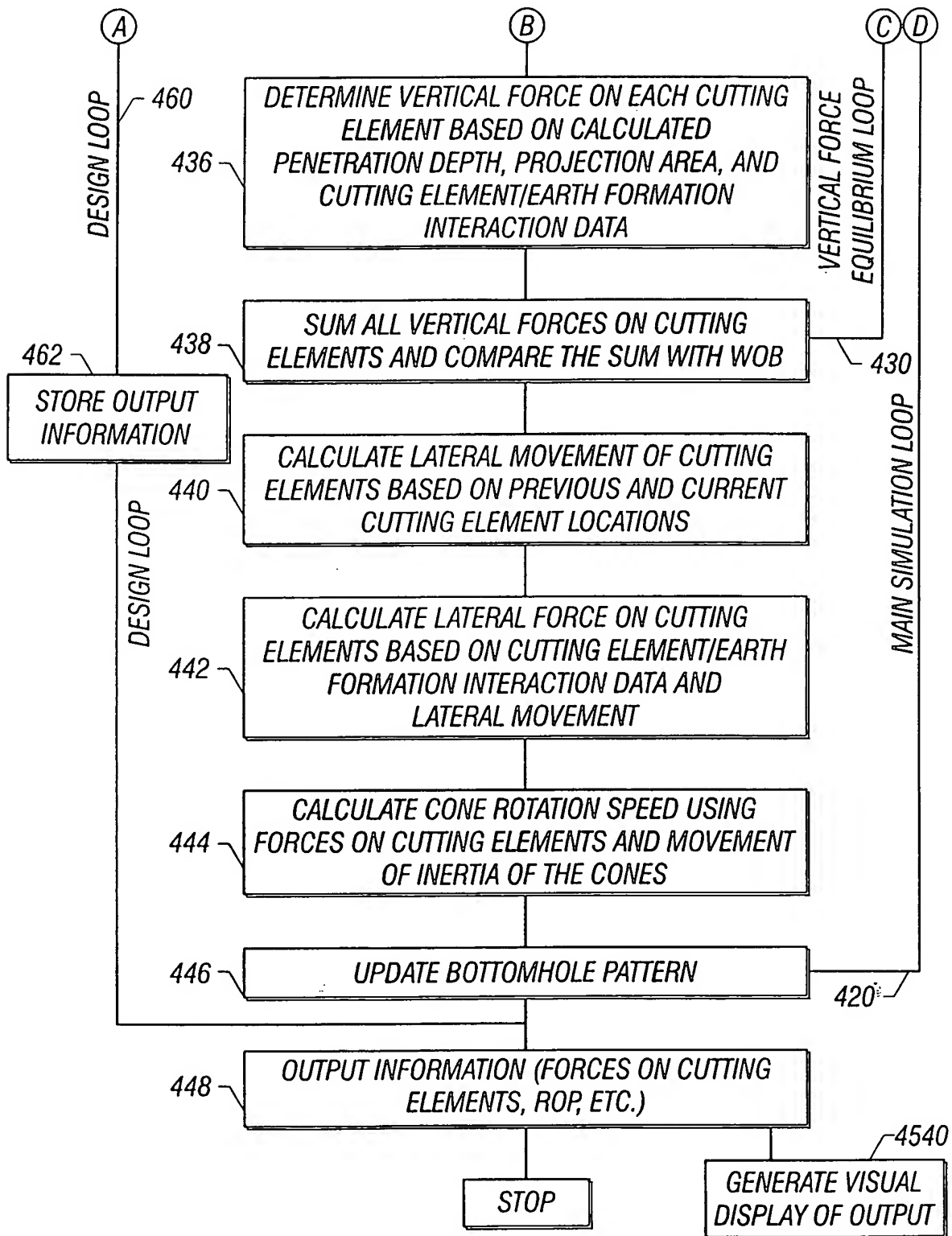
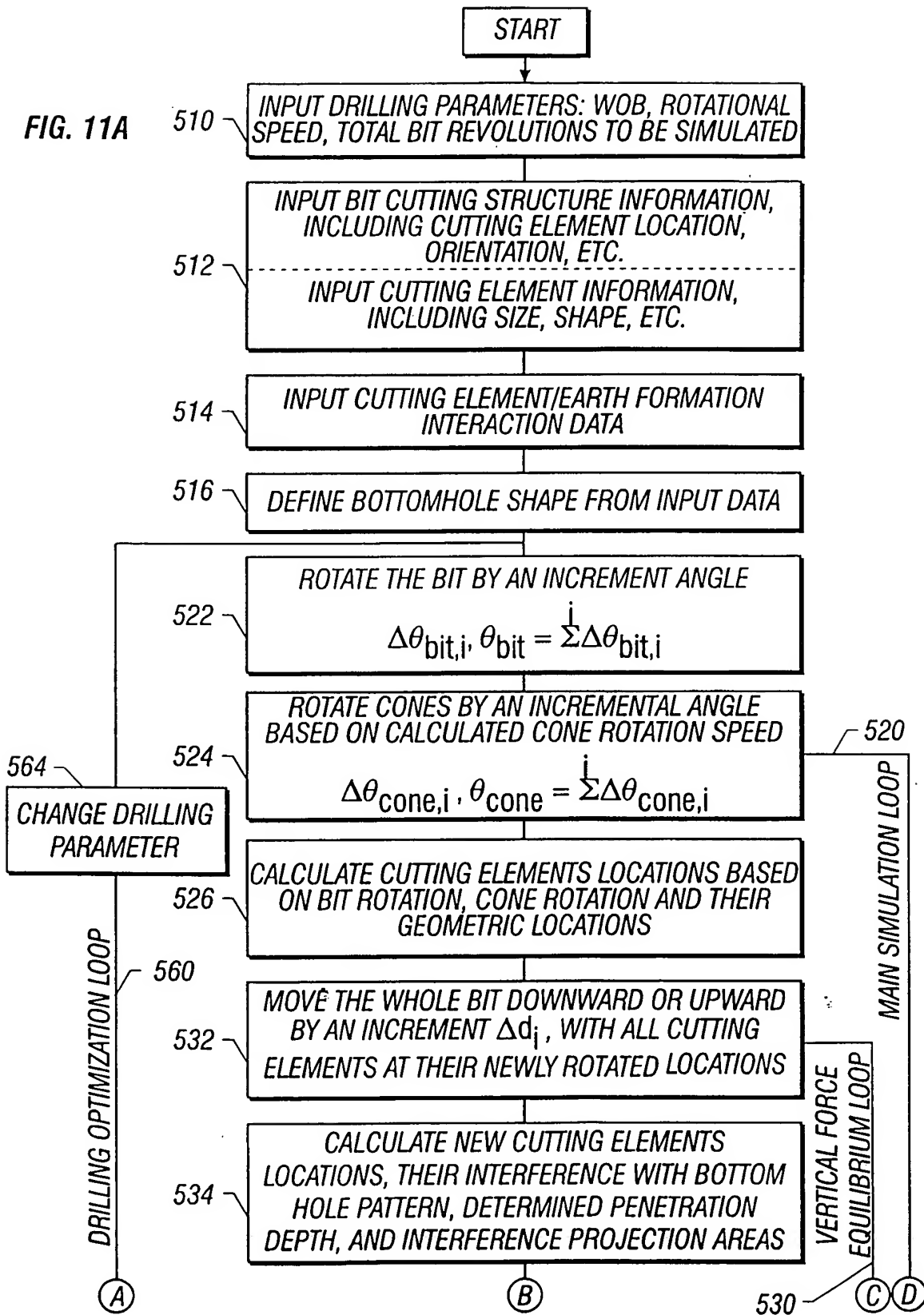


FIG. 10B

FIG. 11A



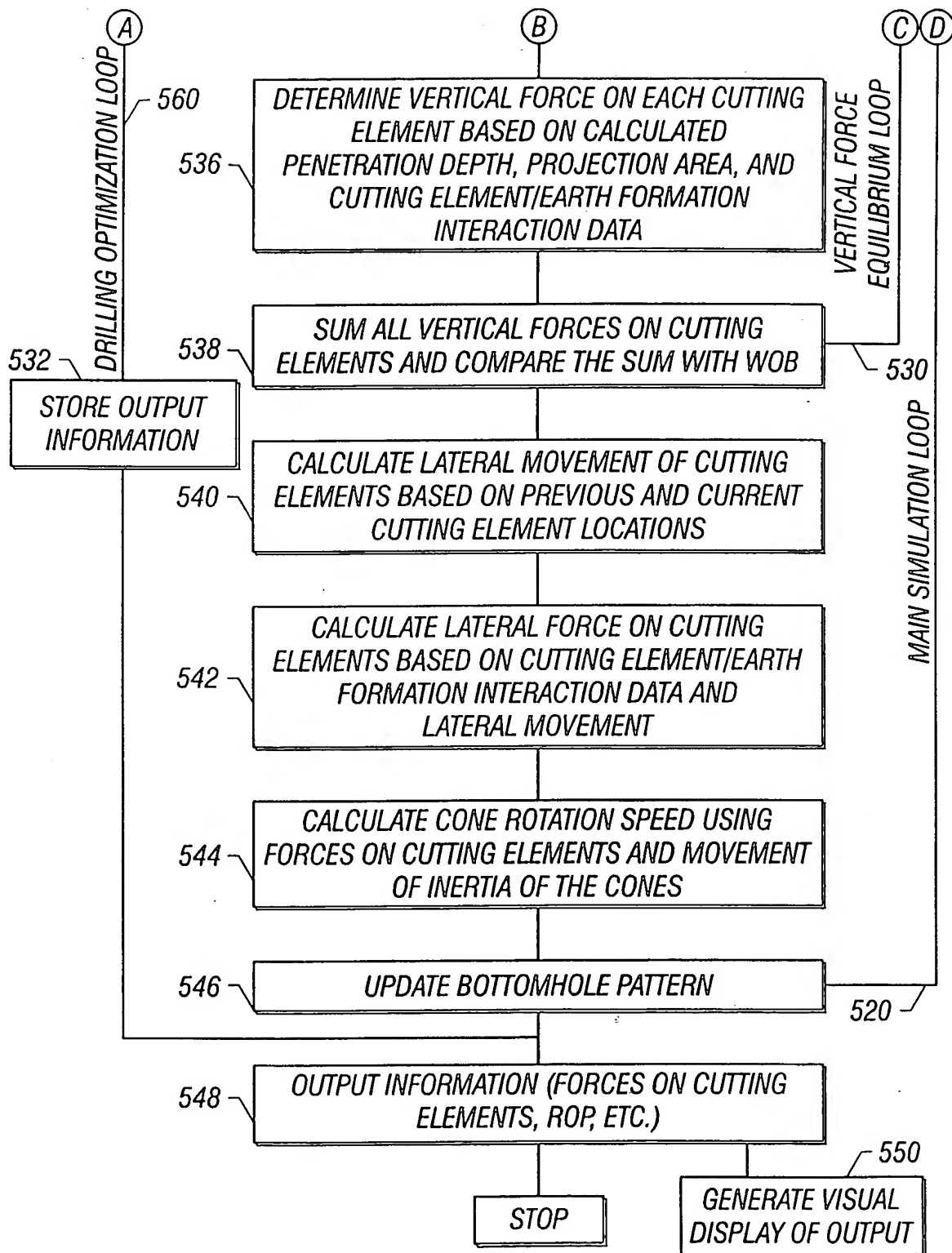


FIG. 11B